

Work Order ID 79086

79086

Page 1

January-19-12 1:43:14 PM

Item ID: D412-630-034 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli Access Step RH Folding
 Start Date: 19/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100	*100*	DOCUMENT CONTROL	0.00
DC		Memo	0.00
Document Control		Photocopy bluefile & create labels per PPP D412-630-034 CHG003	

Handwritten: S126171

110	*110*	Small Fab	0.00
Small Fab		Memo	0.00

Assemble as per dwg D412-630 p.14
 Coat all hardware with LPS3 rust inhibitor
 A/R LPS3 batch: M119317
 COAT exposed HARDWARE WITH LPS PROCYON
 A/R LPS PROCYON BATCH: M114596

Handwritten signature and date: 12/02/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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 Required Date: 02/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 12/02/2012			24 PM			
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				SP 12-02-24.			
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	S 12/02/2012			24 PM			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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79086

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Item ID: D412-630-034

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli Access Step RH Folding

Stop ***NS2***

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

SP 12-02-29

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*MCS 121**ME 12-02-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 1

Work Order ID: 79086

79086

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 *AN310C8* Nut		Purchased	No			110	Each	42.0000	2	8			
									**	SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		42							
				118378		12							
				119324		10							
				120308		20				8x			
AN3C21A *AN3C21A* BOLT		Purchased	No			110	Each	86.0000	2	8			
									**	SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		86							
				109148		2							
				117514		34				8x			
				119798		50							
AN8C16 *AN8C16* Bolt		Purchased	No			110	Each	26.0000	2	8			
									**	m120748 SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST343		26							
				106066		2							
				118451		15							
				119324		9							
										12-02-27.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2012-107

Manufactured No

110

Each

41.0000

1

4

D2012-107

Clevis

**

B75057SP

Location

Loc Qty

Loc Code

ST004

41

71602

3

75057

38

D2803-042

Manufactured No

110

Each

4.0000

1

4

D2803-042

Bracket Assembly

**

EP 12/02/28

B79182 (4X)

Location

Loc Qty

Loc Code

ST149

4

75231

4

D2804-042

Manufactured No

110

Each

5.0000

1

4

D2804-042

Bracket Assembly

**

~~B75057SP~~ EP 12/02/28

B77167 (4X)

Location

Loc Qty

Loc Code

ST150

5

75095

2

76183

3

D2807-041

Manufactured No

110

Each

35.0000

2

8

D2807-041

Door prop

**

B80165 SP

Location

Loc Qty

Loc Code

ST018

35

60540

2

68494

5

73030

10

73920

2

77152

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2813 Manufactured No

D2813

Washer

110

Each

17.0000

2

8

**

B79691 SP

Location

Loc Qty

Loc Code

ST018

17

69386

1

75025

16

D3395-1 Manufactured No

D3395-1

Bushing

110

Each

33.0000

4

16

**

B78840 SP

Location

Loc Qty

Loc Code

ST041

33

71563

33

D3562-042 Manufactured No

D3562-042

Step Assembly, RH

MS21043-3

MS21043-3

Nut

110

Each

0.0000

1

4

**

110

Each

1,243.000

4

16

**

SP 12-02-27.

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

632

119901

632

ST301

539

118077

2

118614

441

118686

30

119758

66

Hex

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79086

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

79086

D412-630-034

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS24665-302

Purchased

No

110

Each

77.0000

2

8

MS24665-302

Cotter Pin

**

SP

Location

Loc Qty

Loc Code

ST309

77

117460

77

8x

MS24693-C280

Purchased

No

110

Each

48.0000

2

8

MS24693-C280

Screw

**

SP

Location

Loc Qty

Loc Code

ST310

48

118612

48

8x

NAS1515H3

Purchased

No

110

Each

151.0000

6

24

NAS1515H3

Washer

**

SP 12-02-27

Location

Loc Qty

Loc Code

ST277

151

116373

6

118078

6

118384

11

119438

28

120142

100

24x

NAS1515H5L

Purchased

No

110

Each

170.0000

4

16

*NAS1515H5L *

WASHER

**

SP 12-02-24

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

130

119902

130

16x

January-19-12 1:43:18 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79086

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H8

Purchased

No

110

Each

139.0000

4

16

NAS1515H8

Washer

**

SP

Location

Loc Qty

Loc Code

ST277

139

111275

4

111411

135

130

Each

42.0000

1

4

AN44C7A

Purchased

No

AN44C7A

Eyebolt

**

SP

Location

Loc Qty

Loc Code

ST362

42

109013

2

111308

40

130

Each

50.0000

1

4

AN4C10A

Purchased

No

AN4C10A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST356

50

112243

20

114523

30

130

Each

109.0000

2

8

AN4C15A

Purchased

No

AN4C15A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST358

109

115835

2

118628

7

118706

100

8x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 79086

79086

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C6A

Purchased

No

130

Each

364.0000

1

4

Sy *AN4C6A*

Bolt

**

SP

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

360

116704

8

119328

152

119749

200

AN5C15A

Purchased

No

130

Each

61.0000

2

8

Sy *AN5C15A*

Bolt

**

4x
SP

Location

Loc Qty

Loc Code

ST338

61

118191

3

118267

33

119749

25

D2806-1

Manufactured

No

130

Each

14.0000

2

8

Sy *D2806-1*

Bushing

**

3 78868

Location

Loc Qty

Loc Code

ST018

14

75047

14

D2806-3

Manufactured

No

130

Each

27.0000

2

8

Sy *D2806-3*

Bushing

**

3 79528 SP
12-02-24

Location

Loc Qty

Loc Code

ST018

27

75046

15

76187

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 79086

79086

Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

*D2810-5

Manufactured No

130

Each

7.0000

1

4

D2810-5

Strut

**

8 B79690 SP

Location

Loc Qty

Loc Code

ST265

7

52034

1

75077

6

Manufactured No

130

Each

12.0000

2

8

D3396-1

D3396-1

Spacer

**

B 78885 SP

Location

Loc Qty

Loc Code

ST041

12

75049

12

Purchased No

130

Each

2,035.000

4

16

MS21043-4

MS21043-4

Nut

**

SP 12-02-24.

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

1525

119309

29

119546

496

120308

1000

110x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 79086

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

581.0000

3

12

MS21043-5

Nut

**

SP

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

136

112314

136

ST301

425

116548

100

118159

100

119307

25

119537

200

12x

NAS1515H4

Purchased

No

130

Each

151.0000

7

28

NAS1515H4

Washer

**

11/20/490 28x SP

12-02-24.

Location

Loc Qty

Loc Code

ST277

151

116169

3

117460

1

117735

3

118078

48

118612

46

120120

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

280.0000


7

28

NAS1515H5

Washer

**

SP 12-02-24. 

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

240

103286

65

~~120299~~

75

120304

100

28x

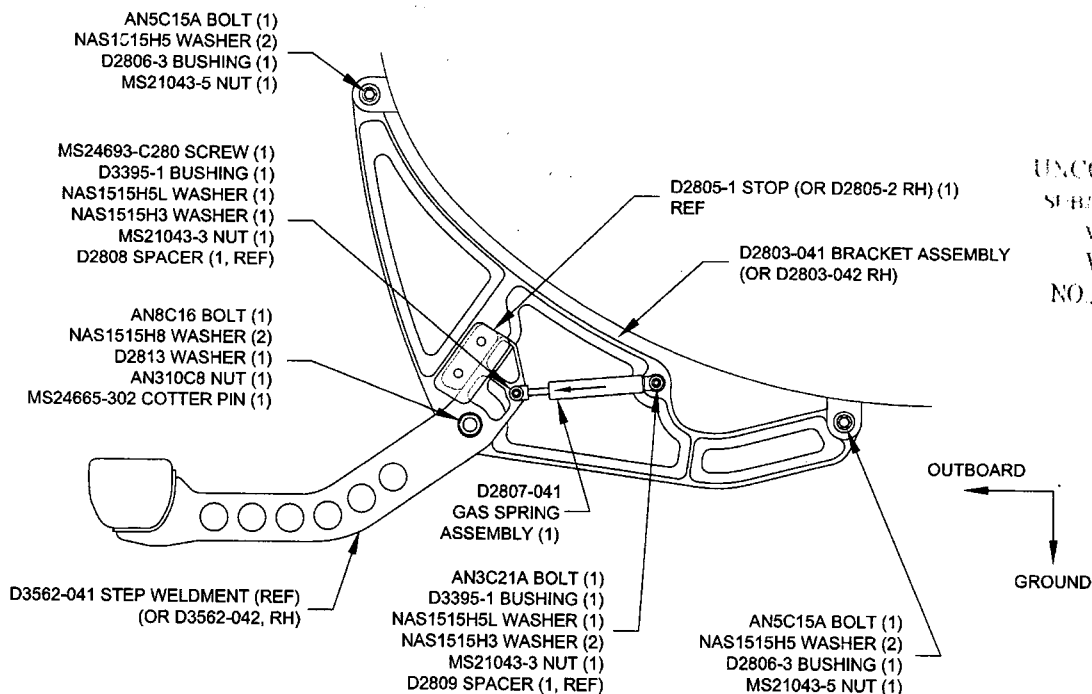
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

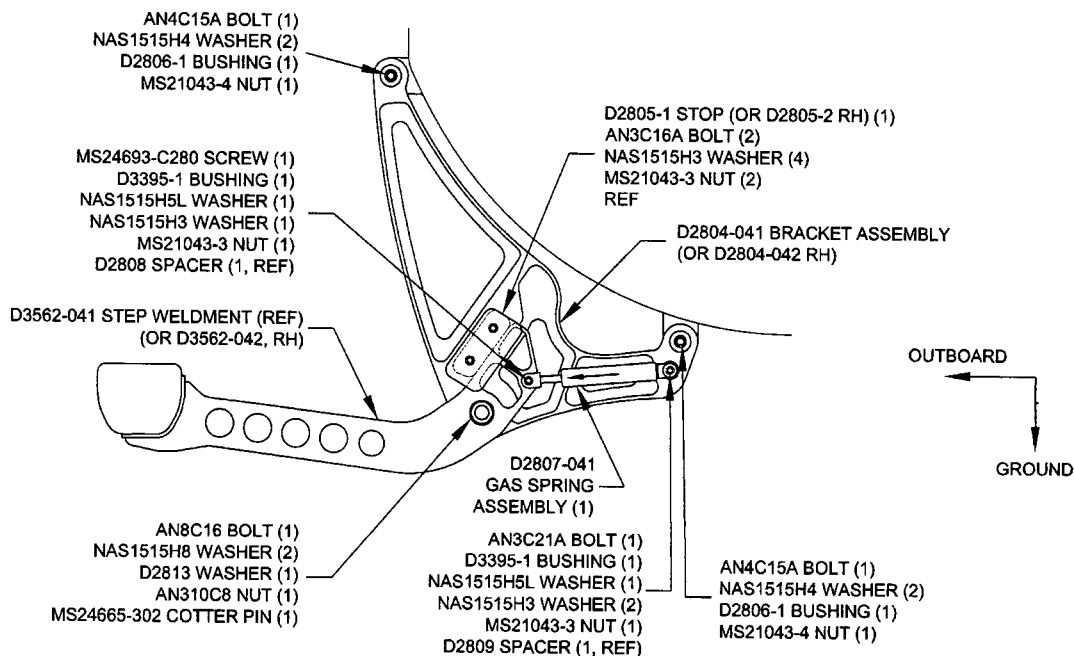
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation

SHOW COPY
REMOVED
UNCONTROLLED COPY
SUBJECT TO VERIFICATION
WILL BE USED
NO. 72084

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12

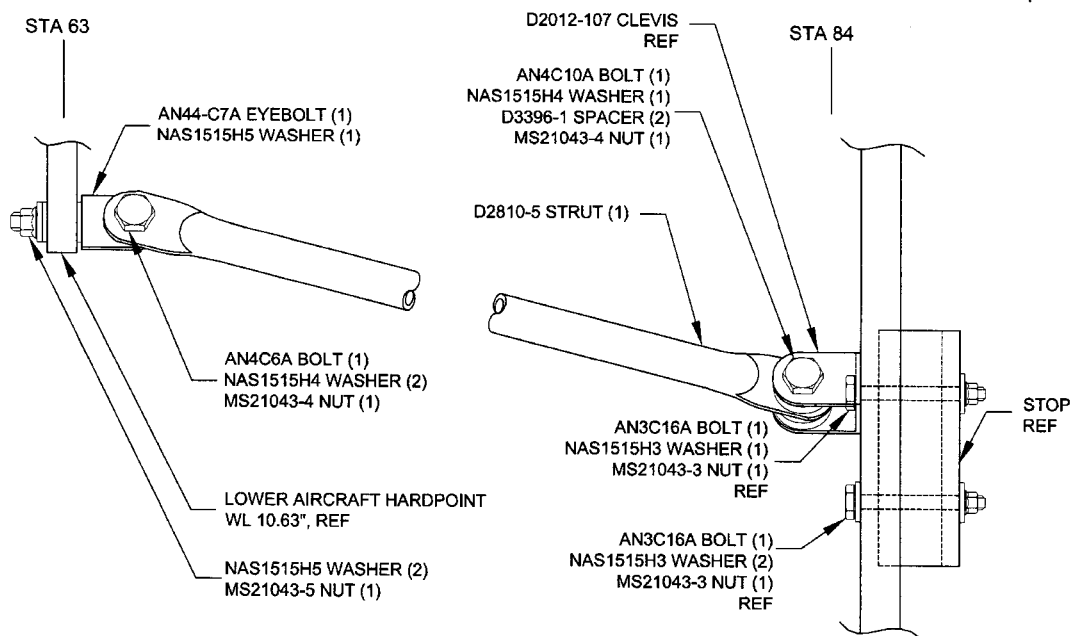
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**FIGURE 16 – Strut Detail for D412-630-033/-034 Heli-Access-Step™ Installation
(NOT TO SCALE)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

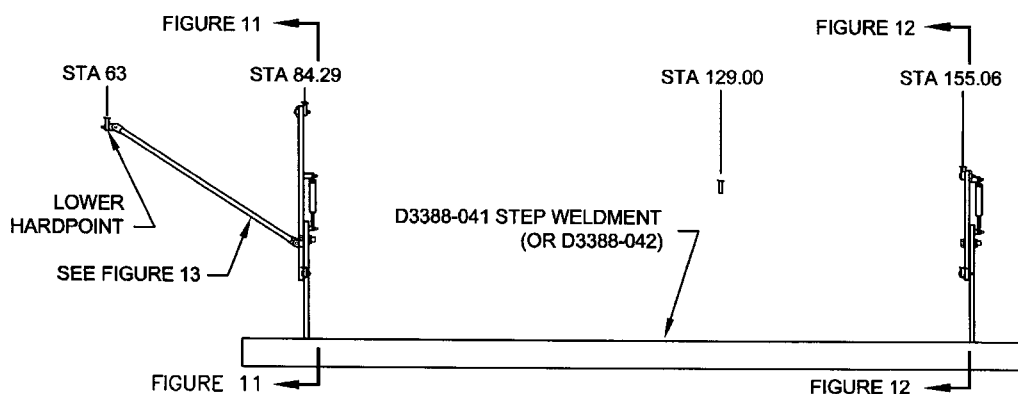
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

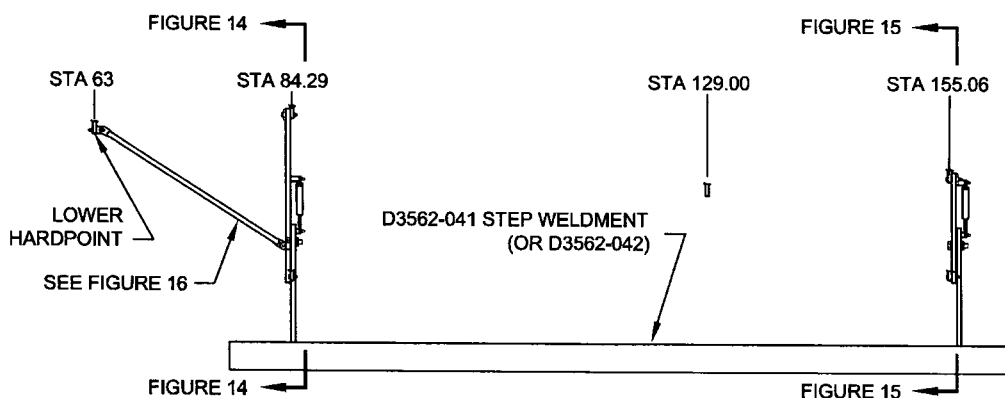
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

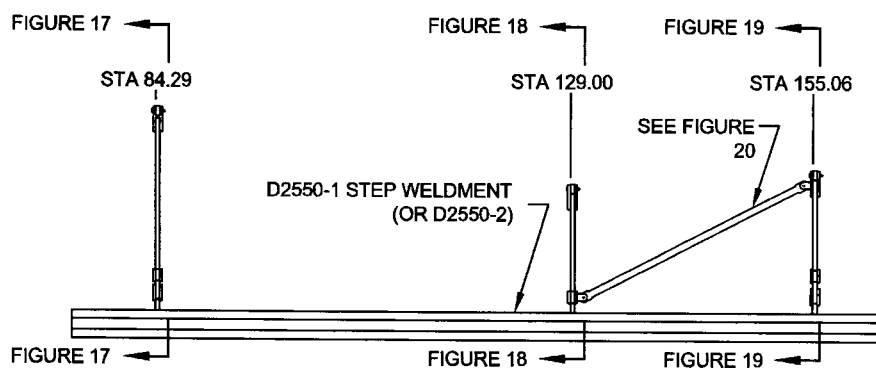


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)